

Work Order ID 67564

Monday, March 28, 2011 11:07:42 AM



Shift work April

Item ID: D4038-11

Accept



Setup Start



Revision ID:

Item Name: Block

Stop



Start Date: 3/28/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan: *JMF*

Date: *11-03-28* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4038

D

100

0.00



Bandsaw

Memo

0.00

CUT BLANK 1.750" LONG

Jeaspa Bandsaw

encl 11/03/29

3

105

0.00



HAAS 1

Memo

0.00

Mill as per Dwg and Folio FA886

DWG REV: *11/03/27*

FOLIO REV: *11/03/27*

HAAS CNC vertical machine #1

encl 11/03/30

3

DEBURR

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

2/11/03/30

3

Quality Control

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

2/13/31

3

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

3 4 2/103/31

Hand Finishing

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

3 BR 11-331

160



Packaging

Packaging

Identify as per dwg & Stock Location: GA

0.00

Memo

0.00

8 1160464

(3)

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/4/4

1112-09-11
(3)

W/O:		WORK ORDER CHANGES							
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Picklist Print

Monday, March 28, 2011 11:07:39 AM

Page 1

Work Order ID: 67564



Parent Item: D4038-11



Parent Item Name: Block

Start Date: 3/28/2011

Required Date: 4/5/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: Ipp Rev:A New Issue 09-12-14 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.00 0		Purchased	No				f	11.0000		0.524211			



6061-T6 Bar 1.50 x 2.00

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT010	11	
110167	1	
114608	10	

524 *MR 11/03/29*

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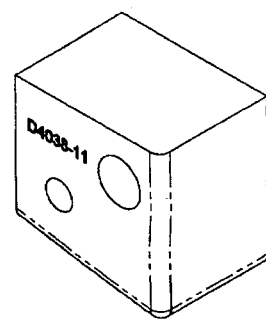
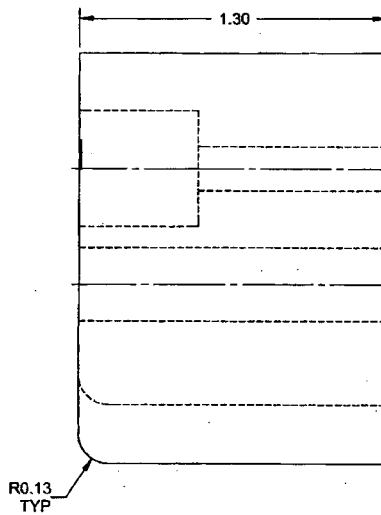
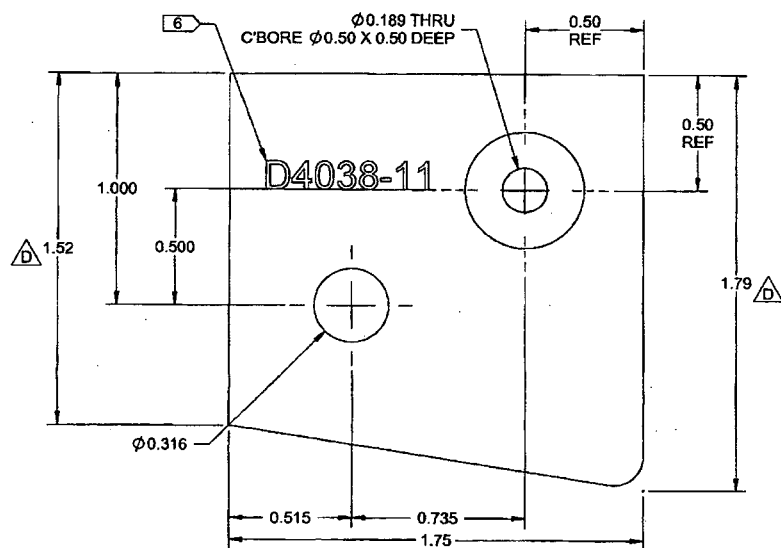
8 7 6 5 4 3 2 1

D

C

B

A



D4038-11 BLOCK

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6081-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
 - 7) WEIGHT: 0.34 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4038	SHEET 13 OF 14
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.03.03	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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67564

RELEASED
2011-03-13

W/O:		WORK ORDER CHANGES						
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